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**UTILITY
PATENT APPLICATION
TRANSMITTAL**

(Only for new nonprovisional applications under 37 CFR 1.53(b)

Attorney Docket No. 2000 1402 Total Pages :

First Named Inventor or Application Identifier

Seiji NONAKA et al.

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APPLICATION ELEMENTS

See MPEP chapter 600 concerning utility patent application contents.

ADDRESS TO: Assistant Commissioner for Patents
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Washington, D.C. 20231

1. <input checked="" type="checkbox"/> Fee Transmittal Form (Submit an original, and a duplicate for fee processing)	6. Microfiche Computer Program (Appendix)
2. <input checked="" type="checkbox"/> Specification (preferred arrangement set forth below) - Descriptive title of the Invention - Cross References to Related Applications - Statement Regarding Fed sponsored R & D - Reference to Microfiche Appendix - Background of the Invention - Brief Summary of the Invention - Brief Description of the Drawings (if filed) - Detailed Description - Claim(s) - Abstract of the Disclosure	7. <input type="checkbox"/> Nucleotide and/or Amino Acid Sequence Submission (if applicable, all necessary) a. <input type="checkbox"/> Computer Readable Copy b. <input type="checkbox"/> Paper Copy (identical to computer copy) c. <input type="checkbox"/> Statement verifying identity of above copies
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3. <input checked="" type="checkbox"/> Drawing(s) (35 USC 113) 4. <input checked="" type="checkbox"/> Oath or Declaration	8. <input checked="" type="checkbox"/> Assignment Papers (cover sheet & document(s)) 9. <input type="checkbox"/> 37 CFR 3.73(b) Statement <input type="checkbox"/> Power of Attorney (when there is an assignee)
5. <input checked="" type="checkbox"/> Newly executed (original or copy) a. <input type="checkbox"/> Unexecuted b. <input type="checkbox"/> Copy from a prior application (37 CFR 1.63(d)) (for continuation/divisional with Box 17 completed) [Note Box 5 below]	10. <input type="checkbox"/> English Translation Document (if applicable) 11. <input checked="" type="checkbox"/> Information Disclosure Statement (IDS)/PTO-1449 <input type="checkbox"/> Copies of IDS Citations
i. <input type="checkbox"/> <u>DELETION OF INVENTOR(S)</u> Signed statement attached deleting inventor(s) named in the prior application, see 37 CFR 1.63(d)(2) and 1.33(b).	12. <input checked="" type="checkbox"/> Preliminary Amendment 13. <input checked="" type="checkbox"/> Return Receipt Postcard (MPEP 503) (Should be specifically itemized)
5. <input checked="" type="checkbox"/> Incorporation By Reference (usable if Box 4b is checked) The entire disclosure of the prior application, from which a copy of the oath or declaration is supplied under Box 4b, is considered as being part of the disclosure of the accompanying application and is hereby incorporated by reference therein.	14. <input type="checkbox"/> Small Entity Statement(s) 15. <input type="checkbox"/> Statement filed in prior application, Status still proper and desired <input type="checkbox"/> Certified Copy of Priority Document(s) (if foreign priority is claimed) 16. <input type="checkbox"/> Other

17. If a CONTINUING APPLICATION, check appropriate box and supply the requisite information:

 Continuation Divisional Continuation-in-part (CIP) of prior Application No. 09/381,680

18. CORRESPONDENCE ADDRESS

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In re application of

Seiji NONAKA et al.

Serial No. NEW : **Attn: Application Branch**

Filed October 6, 2000 : **Attorney Docket No. 2000_1402**

ELECTRODE METAL MATERIAL,
CAPACITOR AND BATTERY FORMED
OF THE MATERIAL AND METHOD OF
PRODUCING THE MATERIAL AND THE
CAPACITOR AND BATTERY

(Continuation-in-part of

Serial No. 09/381,680,

Filed September 23, 1999)

PATENT OFFICE FEE TRANSMITTAL FORM

Assistant Commissioner for Patents
Washington, DC 20231

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Attached hereto is a check in the amount of \$3,930.00 to cover Patent Office fees relating to filing the following attached papers:

Continuation-in-part \$3,890.00

Assignment \$40.00

A duplicate copy of this paper is being submitted for use in the Accounting Division, Office of Finance.

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Respectfully submitted,

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IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

In re application of :
Seiji NONAKA et al. :
Serial No. NEW : **Attn: Application Branch**
Filed October 6, 2000 : **Attorney Docket No. 2000_1402**
ELECTRODE METAL MATERIAL, :
CAPACITOR AND BATTERY FORMED :
OF THE MATERIAL AND METHOD OF :
PRODUCING THE MATERIAL AND THE :
CAPACITOR AND BATTERY :
(Continuation-in-part of :
Serial No. 09/381,680, :
Filed September 23, 1999)

PRELIMINARY AMENDMENT

Assistant Commissioner for Patents
Washington, DC 20231

Sir:

Please amend the above-identified application as follows:

IN THE SPECIFICATION:

Page 1, in the cross-reference immediately following the title of the invention, after
"abandoned", insert --which is a 371 of PCT/JP99/00228 filed January 22, 1999--.

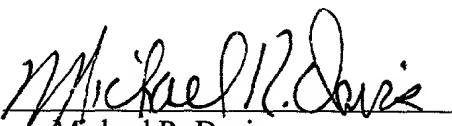
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REMARKS

The cross-reference to the parent application has been revised to indicate that it is a 371 application.

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SPECIFICATION

ELECTRODE METAL MATERIAL, CAPACITOR AND BATTERY
FORMED OF THE MATERIAL AND METHOD OF PRODUCING
5 THE MATERIAL AND THE CAPACITOR AND BATTERY

This is a Continuation-In-Part application of Serial No. 09/381,680 filed on September 23, 1999, now abandoned.

10 FIELD OF THE INVENTION

The present invention relates to an electrode metal material for electrical components such as capacitors and batteries which are used in contact with electrolyte, to a capacitor and a battery formed of the electrode metal material, and to a method of producing the electrode metal material and the capacitor and battery thereof.

15 PRIOR ART

At present, there are, for example, electric double-layer capacitors and electrolytic capacitors available as 20 electrical components which are used in contact with electrolyte. Such electric double-layer capacitors have been applied to large-capacitance capacitors chargeable at up to about 3 V, and used for backup power sources of 25 microcomputers, memory devices, timers, and the like.

Typically, an electric double-layer capacitor comprises a pair of polarizable electrodes or double-layer electrodes disposed face-to-face via an insulating separator

therebetween and immersed in electrolyte. The electrode is produced by applying an activated carbon layer on the surface of an electrode metal material made of a valve metal and used as a mechanical supporter and, at the same time, electric collector.

Some types of electric double-layer capacitors use an organic-solvent based electrolytic solution as electrolyte, such as a tetraethyl ammonium salt which is added to an organic solvent, such as propylene carbonate. The examples of conventional electric double-layer capacitors using organic-solvent based electrolyte include a type in which a pair of electric double-layer electrodes is wound and enclosed in a container, and another type in which a pair of double-layer electrodes is laminated or stacked, both types having been disclosed in U.S. Patent No. 5,150,283.

In the case of the winding type of capacitors, as shown in Fig. 7, an electrode metal material 1 is formed of etched aluminum foil having a thickness of 20 to 50 μm , and a paste obtained from a powder mixture of activated carbon particles, a desired binder and a desired conductive agent is applied to the above-mentioned metal foil to form a film. This film, that is, an activated carbon layer 30 (a polarizable electrode) mainly consisting of activated carbon particles, is used to form an electric double-layer electrode 3.

A lead 6 is connected to each of the electrode metal materials 1 of the pair of electric double-layer electrodes 3 and 3, respectively. These electrodes 3 and 3 are disposed

face-to-face with a separator 5 therebetween and wound like a coil. The electric double-layer electrodes is immersed in non-aqueous electrolyte under vacuum to impregnate the activated carbon layers 30 and the separators 5 with the 5 electrolyte, then placed in an aluminum case 70, the opening 7 of the aluminum case 70 being sealed with a watertight packing 8. The electrolyte in the electric double-layer capacitor has used polypropylene carbonate as an organic solvent, and a tetraethyl ammonium salt as an electrolyte, 10 for example.

Furthermore, in a button-type electric double-layer capacitor, schematically shown in Figs. 9 and 10, activated carbon layers 30 are joined to disc-like sheets 1 made of a valve metal material, respectively, to form a pair of double-layer electrodes 3. The pair of double-layer electrodes 3 and 3 are disposed face-to-face via an insulating separator 5 therebetween, and accommodated in a metal container comprising two mating members. The valve metal material 15 sheets of the two double-layer electrodes are joined to the inner surface sides of the bottom member 60 and the lid member 61 of the metal container. Both the bottom and lid members are joined to each other so as to be watertight by using an insulating ring packing 69 at the peripheral portion 20 thereof. The interior of the capacitor is filled with non-aqueous electrolyte so that the double-layer electrodes and the activated carbon layers are immersed therein sufficiently. The non-aqueous electrolyte is a solution of tetraethyl 25 ammonium perchlorate added in propylene carbonate in the same

way as described above.

An electrolytic capacitor is known as a capacitor in which non-aqueous electrolyte is used. In the anode of the capacitor, a dielectric film is formed by chemically treating the valve metal foil. In the cathode, the valve metal foil is used as it is. Usually, both the electrodes are disposed face-to-face, wound into a coil, and hermetically enclosed in a container while being immersed in electrolyte.

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In the case of the conventional electric double-layer capacitor, the valve metal sheet or foil, on which a polarizable electrode is formed as a film, has a naturally oxidized film specific to the valve metal constituting an electrode structure while the foil is handled. When this foil is used to form an electrode structure, a thin, insulating oxidized film 4 is frequently formed at the interface between the aluminum foil 1 used as a valve metal material and the polarizable electrode 3, as schematically shown in Fig. 6.

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Furthermore, the above-mentioned non-aqueous electrolyte typically includes slight amounts of water and oxygen. For this reason, the valve metal material constituting the electrode structure reacts with the water content in the electrolyte during use of the capacitor, and the surface of the metal is oxidized. Therefore, when the electric double-layer capacitor formed of this kind of metal is used for extended periods of time, its equivalent series resistance

(ESR), i.e., the internal resistance of the capacitor used as a power source, increases gradually, and, in some cases, its capacitance decreases.

5 This problem due to the oxidation of the metal portion of the electrode has also occurred in the case of the button-type electric double-layer capacitor in the same way.

10 Furthermore, the anode of the electrolytic capacitor using non-aqueous electrolyte is provided with a dielectric insulating layer formed by anodizing a valve metal such as aluminum. In addition, its cathode in direct contact with the electrolyte is also formed of the valve metal such as aluminum. In this case, an oxide film is formed on the 15 surface of the metal used for the cathode because of oxidation with the water content in the electrolyte. This causes a problem of the capacitor increasing in internal resistance, just like the problem described above.

20 With respect to batteries using electrodes in contact to non-aqueous electrolyte, a lithium ion secondary battery is known which has high charge-discharge cycle performance with high energy density in a compact shape.

25 A lithium ion secondary battery, as shown in Fig. 11, comprises a positive electrode 35, a negative electrode 37, facing to the positive electrode, a film separator 5 for separating both electrodes 35 and 37, and a non-aqueous electrolytic solution in which both the electrodes are placed and contained in a casing 71. The positive electrode 35 is,

as an example, formed of a mixture of positive active substance such as LiCoO_2 , conductive material such as acetylene black, and a binder including carboxymethylcellulose and polyflorovinylidene which mixture is applied on both sides of aluminum foil as an electrode metal material 1 for an electric collector. On the other hand, the negative electrode 37 is formed of a mixture of negative active substance such as graphite and a binder such as carboxymethylcellulose and styrene-butadiene rubber which mixture is applied on both sides of copper foil as an electric collector. The electrolytic solution is a non-aqueous solvent of a mixture of propylenecarbonate and 1,2-dimethoxyethane containing LiPF_6 as electrolyte. A porous polypropylene film is used as a separator.

In conventional lithium ion secondary batteries, aluminum foil is formed with natural oxide film on its surface during dealing with the foil so that thin isolating film have often been formed in the interface between the aluminum foil and the positive electrode on the aluminum foil.

Further, since the above non-aqueous electrolytic solution also contains slight amount of water and oxygen, the aluminum foil in the battery have been oxidized on its surface, in use, gradually over long time due to reaction of aluminum surface with water in the electrolytic solution, causing a lithium ion secondary battery to increase in equivalent series resistance, i.e., internal resistance and resulting in low capacity at high discharge rate.

SUMMARY OF THE INVENTION

Accordingly, an object of the present invention is to provide a valve metal material capable of being formed into electrodes used in contact with non-aqueous electrolyte to reduce internal resistance of a capacitor or battery.

Another object of the present invention is to provide a method of producing a valve metal material capable of being formed into electrodes used in contact with non-aqueous electrolyte to reduce internal resistance of such a capacitor or battery.

A still another object of the present invention is to provide a capacitor capable of having a low internal resistance by restricting the change in the resistance of the electrode metal material constituting the electrodes used in contact with non-aqueous electrolyte.

A still another object of the present invention is to provide a non-aqueous secondary battery having low internal resistance by restricting the change in the resistance of the electrode metal material constituting the electrodes used in contact with non-aqueous electrolyte.

A yet still another object of the present invention is to provide a method of producing a capacitor capable of having a low internal resistance by restricting the change in the resistance of the electrode metal material constituting the electrodes used in contact with non-aqueous electrolyte.

A yet still another object of the present invention is to provide a method of producing a non-aqueous secondary battery having low internal resistance by restricting the change in the resistance of the electrode metal material constituting the electrodes used in contact with non-aqueous electrolyte.

An electrode metal material in accordance with the present invention is formed of a valve metal material containing carbon particles on the surface, and is used to form electrodes. The carbon particles in the carbon-containing metal material ensure direct contact with a conductor (including electrolyte) to electrically connect the electrode metal material to the conductor.

In particular, the carbon-containing metal material comprises a valve metal material and numerous carbon particles fixed in the surface of the valve metal material and exposed to the surface. In the present invention, the carbon particles may be projected slightly so as to be exposed to the surface of the valve metal material in order to enhance the conductivity and joining characteristic to a conductor to become contact therewith.

The electrode metal material in accordance with the present invention may be used to obtain electrode structures used in contact with non-aqueous electrolyte. This kind of carbon-containing metal material itself may be an electrode making contact with electrolyte. Alternatively, the

electrode metal material may have an activated carbon layer coated on the surface, i.e., a polarizable electrode. The former corresponds to the cathode of an electrolytic capacitor, and the latter corresponds to the double-layer electrode of an electric double-layer capacitor.

Further, the electrode metal material may be used to support a positive electrode including a positive active substance on the surface of the electrode metal material, the positive electrode being used for a non-aqueous electrolytic secondary battery, e.g., a lithium ion secondary battery.

In the electrolytic capacitor, the carbon particles of the carbon-containing metal material, exposed to the surface thereof, can make direct contact with the electrolyte to ensure conductivity between the metal material and the electrolyte. In addition, inside the electric double-layer capacitor, the carbon particles of the carbon-containing metal material, exposed to the surface thereof, can make direct contact with the activated carbon layer to ensure conductivity between the metal material and the activated carbon layer. Further, in the lithium ion secondary battery, the carbon particles of the carbon-containing metal material are exposed to the surface thereof, to make direct contact with the active substances in the positive electrode, ensuring conductivity between the electrode metal material and the positive electrode.

In any of the cases, even if the carbon-containing metal material makes contact with electrolyte solution, and the metallic surface thereof is oxidized by water contained in

non-aqueous electrolyte, the conductivity noted above remains almost unchanged over long time periods.

More particularly, numerous carbon particles may project
5 on the surface of the valve metal material. Therefore, it is preferable that only the metal surface of the valve metal material may be removed such that the carbon particles are left projected on the removed surface. This projection configuration of the surface of the valve metal material ensures conductivity to the activated carbon layer in the 10 capacitor or active substance in the battery, and also enhances strength of joining to the activated carbon layer or positive electrode.

15 More particularly, the metallic surface of the valve metal material may be coated with a passive film. In this case although the metallic surface of the valve metal material itself may lose conductivity, the metallic surface is prevented stably from oxidation because of no contact with 20 the electrolyte, and the valve metal material has stable conductivity via the carbon particles for extended periods of

The valve metal material in accordance with the present invention can be formed into sheet. The term "sheet" herein 25 refers to plate, sheet, film and foil. The valve metal material may be formed of products other than sheet, having a small thickness with a desired shape. The electrode metal material may have a shape of net or punched plate. this may be is adequate to apply, for example, the positive electrode

thereon to produce non-aqueous secondary battery.

5 The sheet and other formed products may include carbon particles at least on one side thereof and also may include carbon particles on both sides thereof.

10 A method of producing a valve metal material for electrodes in accordance with the present invention contains driving or squeezing numerous carbon particles into the surface thereof. Pressing using dies or rolling using rollers may be employed to drive powder of carbon particles into a valve metal sheet, then, carbon particles being fixed in the surface of the valve metal sheet with the particle exposed on the surface.

15 Another method may be adopted where a slurry of carbon particles is applied and dispersed on a surface of a valve metal material and pressed to squeeze the carbon particles into the surface, then, obtaining carbon-containing electrode 20 metal material. The carbon slurry may comprise carbon particles and a solvent, particularly, volatile dispersing liquid without any binder used. The dispersing liquid may be water, alcohol or other volatile liquid because after drying, it is preferable that only carbon particles remain dispersed 25 on the surface without containing any impurity such as binder solid.

Prior to pressing in the above methods, the valve metal material may preferably be roughened on the surface, particularly be made porous in a thin layer of the surface,

facilitating carbon particles to engage and embed in the porous surface layer effectively.

Also, a method of producing the valve metal material for electrodes in accordance with the present invention may include a step wherein the powder material for the valve metal and carbon particles are semi-melted in a mixture condition and subjected to pressure so as to be formed into a dense metal ingot. The metal ingot, including carbon particles dispersed inside, is forged or rolled into a product having a desired shape, and then the carbon particles are exposed to the surface of the product.

BRIEF DESCRIPTION OF THE DRAWINGS

The present invention will be described below in detail referring to the accompanying drawings, in which:

Fig. 1 is a schematic sectional view showing an example of a carbon-containing valve metal material in accordance with the present invention, wherein carbon particles are fixed in the surface of the valve metal sheet;

Fig. 2 is a schematic sectional view showing another example of a carbon-containing valve metal material in accordance with the present invention;

Fig. 3 is a schematic sectional view showing still another example of a carbon-containing valve metal material in accordance with the present invention;

Fig. 4 is a schematic sectional view showing yet still another example of a carbon-containing valve metal material in accordance with the present invention, wherein carbon

particles are fixed on both sides of the valve metal sheet;

Fig. 5 is a schematic partially-sectional view showing a double-layer electrode used for an electric double-layer capacitor formed of the carbon-containing valve metal material in accordance with the present invention;

Fig. 6 is a schematic partially-sectional view showing a double-layer electrode used for a conventional electric double-layer capacitor;

Fig. 7 is a schematic partially-cutaway perspective view showing a winding type electric double-layer capacitor;

Fig. 8 is a schematic partially-sectional view showing a double-layer electrode used for a button-type electric double-layer capacitor formed of the carbon-containing valve metal material in accordance with the present invention;

Fig. 9 is a schematic sectional view showing the button-type electric double-layer capacitor;

Fig. 10 is a schematic partially-cutaway perspective view showing the button-type electric double-layer capacitor.

Fig. 11 shows a schematic partial cross sectional view of a non-aqueous secondary battery; and

Fig. 12 shows a cross sectional structure of a positive electrode for a non-aqueous secondary battery which is formed on both sides of an carbon containing electrode metal material according to the present invention.

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DETAILED DESCRIPTION OF THE INVENTION

A valve metal material for electrodes in accordance with the present invention includes carbon particles fixed on the surface thereof as described above. The valve metals can be

selected from among metals capable of forming a passivated layer on the surface thereof. For example, such valve metals may include tantalum, aluminum, titanium, niobium, zirconium, bismuth, silicon and hafnium. Alternatively, the valve metal 5 can be selected from among alloys including these elements capable of generating a valve action, such as for example, a titanium-based alloy including boron and tin, a titanium-based alloy including chromium and vanadium, a titanium-based alloy including vanadium and antimony, and an aluminum-based alloy including titanium. The most desirable material is 10 aluminum, in particular, high-purity aluminum.

The electrode metal material of the present invention is formed into the form having a desired thickness, for example, 15 into sheet. The thickness of the sheet may be in a range of 10 μm to 5 mm, although the thickness depends on the kind of capacitor or battery, or the kind of electrode. Generally, for winding type electric double-layer capacitors and electrolytic capacitors, metal foil having a thickness of 50 to 20 500 μm is preferably used to provide flexibility and sufficient winding turns. On the other hand, for button-type electric double-layer capacitors, the valve metal material, when also used as a part of the wall or bottom portion of the 25 container, should preferably have a larger thickness of about 0.50 to 3.0 mm, for example, to provide strength to the wall or bottom portion.

A base metal plate for providing strength may be cladded with the above-mentioned thin valve metal material, and

carbon particles may be included in the clad valve metal material used. A highly corrosion-resistant metal or alloy, such as nickel or stainless steel, may be used as this kind of base metal. Such base metal plate cladded with valve metal material may be used for a casing which also supports a positive electrode of button- or coin-type secondary batteries.

On the other hand, carbon particles are formed of conductive carbon particles, such as graphite or carbon black. Carbon black as an example may be acetylene black. Furthermore, carbon particles may be particles of activated carbon.

The diameter of carbon particles should preferably be in the range of 0.01 to 50 μm , more preferably, in the range of 0.1 to 10 μm . In addition, the carbon particles can have one of particulate, granular and fibrous forms. In the case of fibrous carbon particles, the above-mentioned particle diameter in the range of 0.1 to 50 μm refers to the fiber length thereof.

The content of carbon particles should preferably be in a range of 1 to 90% of the area percentage of the carbon with respect to the whole surface area of the valve metal material. If the area percentage of the carbon is less than 1%, it may be difficult to sufficiently reduce contact resistance at the surface. The area percentage of the carbon should preferably be higher. However, if the area percentage of the carbon is more than 90%, it becomes difficult to stably hold carbon

particles pressed into the surface of the valve metal by a press method. Accordingly, the area percentage of the carbon particles on the surface should preferably be in a range of 5 to 60%, more preferably, in a range of 10 to 40%.

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The valve metal material should preferably have a rough surface. In particular, carbon particles should preferably project slightly from the surface of the metal material. The projection of the carbon particles can be performed by subjecting the surface to electrolytic etching in an acidic aqueous solution. The exposure of numerous carbon particles can increase contact frequency to an activated carbon layer for an electric double-layer electrode structure. Furthermore, the activated carbon layer can be firmly fixed by an anchor effect. Also, the exposed carbon particles from the electrode can increase contact frequency to active substance contained in the positive electrode of non-aqueous secondary batteries.

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Fig. 1 shows a carbon-driven metal material 1 wherein nearly particulate carbon particles 2 are driven on one side of a sheet of valve metal material 10. This figure shows a schematic view of an example of the valve metal material in which the carbon particles 2 are partially embedded in the surface of the metal material and the upper portions thereof project from the surface.

Fig. 2, similar to Fig. 1, is a conceptual view showing a condition wherein the carbon particles 2 are crushed and wholly embedded in the surface of the metal material.

However, in the carbon-driven metal material 1, the surfaces of the carbon particles are still exposed to the surface of the metal material, and the carbon particles can be used to ensure conductivity. This condition may be obtained when 5 relatively soft carbon particles are pressed strongly.

Fig. 3 is a view showing a condition wherein the carbon-driven metal material 1 shown in Fig. 2 is subjected to electrolytic etching to remove its metallic surface 11, thereby allowing the carbon particles to project from a etched surface. Fig. 4 is a view showing a condition wherein the carbon particles driven on both sides of the sheet of the valve metal material which sides are subjected to etching, thereby allowing the carbon particles to project from both etched surfaces. 10 15

Furthermore, the whole surface of the carbon-containing metal material may be roughened by blasting. Blasting makes the surface of the valve metal material rough directly, and 20 the carbon particles expose. In addition, for electric double layer capacitors, the activated carbon layer can be fixed firmly to the roughened surface, and the contact resistance of the surface can be reduced.

25 A passive film may preferably be formed on the surface of the carbon-containing metal material (for example, the metallic surface 11 shown in Figs. 3 and 4). Even if water is present in electrolyte while the valve metal material is used as an electrode, the passive film protects the surface

of the valve metal material against oxidation and corrosion. Therefore, the electrodes can be stabilized further, without adversely affecting the conductivity thereof due to the existence of the carbon particles.

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The passive film may have only a thickness capable of withstanding working voltage of a capacitor comprising the film. For example, in the case of an electric double-layer capacitor rated at 2.5V to 3.5V, the film should only have a thickness capable of withstanding a voltage in the range of 4 to 5 V. In this case, the valve metal material is provided with a passive film having a thickness of 40 Å to 60 Å or more. Also, for the positive active electrode of non-aqueous secondary batteries, the passive film formed on the carbon containing electrode metal material may have higher withstand voltage than 3V, preferably of 4 to 5V.

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With respect to lithium ion secondary batteries, Fig. 11 shows a winding-type lithium ion secondary battery, in which a pair of electrodes i.e., a positive electrode 35 and a negative electrode 37, between which a separator 5 is inserted, are wound, penetrated with an non-aqueous electrolyte in a casing 71 for sealing.

An electrode metal material of the present invention is used to form the positive electrode 35 which comprise an mixture of positive active substance, conductive material and a binder which is formed on both sides of the electrode metal material. The positive active substance may be a compound capable of absorbing and emitting any ions of H^+ , Li^+ , Na^+

and K^+ , preferably, oxides or chalcogenides of transition metals, or carbon, particularly, lithium-containing transition metal oxides. The transition metal may be one or more selected from a group of Co, Ni, Fe, V and Mn. A conductive material may be an electron-conductive material not to chemically react in the battery, such as natural graphite, synthetic graphite, carbon black, acetylene black or carbon fibers. As a binder, polysaccharides, thermoplastic resins or rubber-like elastic polymers may be used. A binder may include starch, polyvinylalcohol, carboxymethylcellulose, hydroxy-propylcellulose, polyflorovinylidene, etc.

An electrolyte comprises an organic solvent and a salt soluble to the solvent to dissociate. A solvent may be one or a mixture of propylene carbonate, ethylene carbonate, tetrahydrofuran, 2-methyltetrahydrofuran, γ -butyrolactone, and 1,2-dimethoxyethane. The salt as an electrolytic substance may be selected from $LiPF_6$, $LiClO_4$, $LiBF_4$ and $LiCF_3SO_3$.

The separator 5 may be thin insulating material capable of penetrating an electrolyte therethrough such as polypropylene porous film, woven or unwoven glass cloth, paper made of manila paper and rayon.

In this battery structure, Fig. 12 shows a cross sectional structure of a positive electrode 35 for a non-aqueous secondary battery which is formed on both sides of an carbon containing electrode metal material 1 according to the present invention. Since the electrode metal material 1 of the present invention which supports the positive electrodes

35 is provided with carbon particles on its surface, the carbon particles 2 can effectively connect the electrode metal material 1 of a valve metal 10 directly with a positive electrode 35 effectively even though a thin insulating film 4 has been formed in interfaces between the metallic surface of the electrode metal material 1 and the positive electrode 35 by oxidation of the metallic surface of the electrode material metal. This results in reduction in equivalent series resistance and capacity loss of batteries.

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Some methods may be adopted to produce an electrode metal material formed of a valve metal material containing numerous carbon particles at least in the surface thereof.

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In a first method, a mixture of valve metal powder and carbon powder is heated near its melting point and pressurized in a container to make an ingot so that the carbon powder may be contained in the valve metal ingot. This method further includes a step of subjecting the ingot of carbon-containing valve metal produced by the above step to plastic working in order to obtain a desired shape of the valve metal material. In the plastic working step, hot or cold forging or rolling can be utilized, whereby forming sheet or foil having a desired thickness or a formed product having any other shapes.

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A second method includes a carbon-powder driving step wherein carbon particles are driven into the surface of a valve metal material by pressurizing carbon particles

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dispersed on the surface of the valve metal material.

5 The carbon particle driving step in the second method can also be accomplished by a press technique where dies are used to press and fit carbon particles into the surface of the valve metal material. The dies may have a flat, hardened plate or the like.

10 Furthermore, the carbon particle driving step can also be accomplished by a rolling method wherein rollers are used to drive carbon particles into the surface of the valve metal material. In either of the two methods, carbon particles can be pressed and fitted in the surface of the valve metal material and fixed.

15 By using the second method, carbon particles are driven in the surface of the valve metal material having a desired thickness. The above-mentioned carbon particle driving step can be performed by applying a surface pressure of 0.5 to 20 10000 kg/cm² in a direction perpendicular to the surface of the metal material. This pressure is determined depending on the hardness of the surface of the valve metal material and the hardness and particle size of the carbon particles.

25 Furthermore, the carbon particle driving step may also be used as a step of pressing or forging a valve metal blank into a formed product having a desired shape. In other words, in this case, the carbon particle driving step is carried out when the valve metal ingot is hot or cold worked. In this

step, just when the valve metal material is pressurized by hot or cold forging or rolling, the carbon particles are driven into the forged or rolled surface.

5 Prior to the carbon particle driving step, numerous carbon particles are dispersed on the surface of a valve metal material, for example, in the form foil, sheet or plate. Usually, carbon powder may be powdered on the surface.

10 Preferably, a slurry containing carbon particles and liquid may be applied on a surface of a valve metal material, facilitate the dispersing of carbon particles. The liquid in the slurry may be a volatile dispersing liquid to facilitate dehydration of the slurry. The slurry may not contain a binder which remain in a powder after drying. The dispersing liquid may be water, alcohol or other volatile liquid because after drying, it is preferable that only carbon particles remain dispersed on the surface without containing any impurity such as binder solid. Preferably, the carbon slurry may be dried on the surface of the valve metal material, and 20 in the carbon particle driving step, is pressed to squeeze the carbon particles into the surface, obtaining carbon-containing electrode metal material.

25 Prior to pressing in the above methods, the valve metal material may preferably be roughened on the surface, allowing carbon particles to engage and embed easily on the rough surface.

A technique for roughening a surface includes blasting sand or other harden powder onto the surface. Other

roughening method includes chemical or electrolytic etching which makes the surface porous in a thin layer under the valve metal surface. By this etching, a great number of pores are produced opening to the surface of the valve metal
5 material and extending in some depth under the surface and dispersed uniformly in an area of the surface.

Such a roughened or porous surface may easily receive and hold the applied carbon powder or dried carbon slurry on the surface, preventing the carbon particles to be sent flying. Roughening of a valve metal surface can eliminate the need for use of any binder mixing in the carbon slurry, avoiding impurity inclusion on the carbon embedded surface.
10

Particularly, the porous surface layer formed by etching is easy to be deformed by pressing or rolling on the surface, allowing carbon particles to be embedded easily in high carbon density into the surface-deformed layer from the porous surface layer during pressing or rolling.
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The roller used in rolling may be an roller embossed on its surface. The embossed roller can make an embossed pattern on the carbon embedded surface at the same time during driving carbon particle driving.
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Furthermore, in the method in accordance with the present invention, the surface of the carbon containing metal material may preferably be coarsened after the carbon particle driving step.
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For this purpose, it is desired that, after the carbon particle driving step, the method includes a step of exposing

the carbon particles to the surface by electrolytically etching in an acidic aqueous solution. By this treatment, the carbon particles exposed on the surface project from the surface and carbon particles slightly embedded below the surface also are exposed to the surface. The exposure of numerous carbon particles can increase the contact frequency of an activated carbon layer for an electric double-layer electrode structure. Furthermore, the activated carbon layer can be firmly fixed by an anchor effect.

10 After the carbon particle driving step, the method may include blasting as a step of exposing carbon particles to the surface. This blasting technique can also accomplish direct roughing of the surface and exposing of the carbon particles by blasting.

15 The production method may preferably include a step of forming a passive film on the metallic surface of the carbon containing metal material after the carbon particle exposing step. Formation of the passive film may use a technique of 20 heating the carbon-containing metal material oxidized in an oxidative atmosphere, such as in air. The heat treating is performed at 300 - 620°C.

25 Alternatively, another method is used, wherein the carbon-containing metal material is anodized using anodic oxidation of a metallic surface of the valve metal.

The passive film should have a thickness capable of withstanding an applied voltage of 4 to 5 V in the case of an electric double-layer capacitor rated at 2.5 to 3.5 V, for example. In this case, the valve metal material is provided

with a passive film having a thickness of 40 Å to 60Å or more.

5 Capacitors in accordance with the present invention include electric double-layer capacitors and electrolytic capacitors. In both types of the capacitors, non-aqueous electrolyte is used, and the valve metal material thereof makes contact with the electrolyte.

10 Fig. 7 is a schematic view showing a winding type capacitor used as a kind of electric double-layer capacitor. The winding type capacitor is provided with flexible electric double-layer electrodes. The electrode comprises thin valve metal foil used as a valve metal material, and activated carbon layers bonded to both sides of the foil. Numerous carbon particles are fixed on the surface of the foil so as to expose, thereby making contact with the activated carbon layers.

15 A pair of electric double-layer electrodes, holding a separator therebetween, is wound to a coil and enclosed in a container while being immersed in non-aqueous electrolyte, thereby forming an electric double-layer capacitor. The electrolyte is formed of an organic solvent not including water and a salt dissolved in such a solution so as to be 20 dissociated. A solution wherein tetraethyl ammonium perchlorate used as an electrolyte is added to propylene 25 carbonate used as a solvent is taken as an example.

The activated carbon layer is formed in a thin film by

forming activated carbon powder into a paste form and by applying the paste to the surface of the valve metal foil. The paste is obtained, for example, by kneading a mixture of activated carbon powder, conductive carbon powder and an appropriate binder, such as cellulose or fluororesin, as necessary, together with water or other solvent. The coated paste film is appropriately dried and heated together with the valve metal foil to cure the binder, whereby the film is fixed to obtain an electric double-layer electrode.

10

Leads are connected to the pair of electric double-layer electrodes, one lead to each electrode. Furthermore, the electrodes were wound while holding a separator therebetween so as to be formed into a coil. The separator is formed of an appropriate thin material that is insulating and water-permeable, such as glass-fiber woven or non-woven cloth.

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The coil comprising the electric double-layer electrodes and the separator is immersed in electrolyte and accommodated in a metal container having a bottom. The opening of the container is sealed with a sealing material. The leads pass through the sealing material and are extended outside.

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With the above-mentioned structure of the electrode, even when a thin insulating film 4 is present at the interface between the foil-like metal material 10 of the electrode metal material 1 and the polarizable electrode 30 of the electric double-layer capacitor as shown in Fig. 5, no oxidized film is formed on the surfaces of carbon particles 2

exposed from the electrode foil 10. For this reason, electric conduction can be maintained by the carbon particles 2 at portions wherein the carbon particles 2 are present. As a result, the equivalent series resistance (ESR) of the 5 electric double-layer capacitor decreases, and the conduction portions increase in number, whereby the capacitance thereof increases.

10 Figs. 9 and 10 show a button-type electric double-layer capacitor. An activated carbon layer 30 is bonded to a disc-like sheet 10 formed of the valve metal material of the present invention via an adhesive layer 9, thereby forming a pair of double-layer electrodes 3. The two double-layer electrodes 3 are disposed face-to-face with an insulating 15 separator 5 therebetween, and accommodated inside a metal container comprising two mating portions 60 and 61.

20 The valve metal material sheets 10 and 10 of the two double-layer electrodes 3 and 3 are joined to the inner surface sides of the bottom portion 60 and the lid portion 61 of the metal container, respectively. The bottom portion and the lid portion are then joined to each other at their 25 peripheral portions so as to be watertight via an insulating ring packing 69. The container is filled with non-aqueous electrolyte so that the double-layer electrodes and the activated carbon layers are sufficiently immersed in the electrolyte. The non-aqueous electrolyte may be, for example, a solution of tetraethyl ammonium perchlorate used as an electrolyte in propylene carbonate used as a solvent, as 25

described above.

Double-layer electrodes 3 for the button-type electric double-layer capacitor are shown in Fig. 8. The activated carbon layer 30, i.e., the polarizable electrode 30, is formed of a sheet made of activated carbon particles or fibers.

For example, the activated carbon layer 30 is obtained as described below. A paste is prepared by mixing activated carbon powder, a solvent and an appropriate binder, and this paste is formed into thin film, which are dried and cured to obtain sheets including activated carbon particles. The sheets are used as the activated carbon layer 30.

The sheet of activated carbon fiber is formed of fiber activated at the carbonization step of phenol-based resin fiber, for example. The activated carbon fiber is woven into a sheet.

The above-mentioned activated carbon particle sheet or the activated carbon fiber sheet is stamped into sheet pieces having a desired shape, and the sheet pieces are bonded to the carbon-containing side of the valve metal material sheet so as to be assembled into the double-layer electrode 3. An organic adhesive 9, being conductive, is usually used for the bonding.

The conductive adhesive may be used to firmly bond a

sheet of chemically active carbon fiber or the like to the valve metal material sheet. Furthermore, the adhesive 9 is used to electrically connect the carbon particles on the valve metal material side to some parts of the fiber and 5 particles on the activated carbon side. The carbon particles 2 on the valve metal material side ensures conductivity at the double-layer electrode 3 via the adhesive layer 9, thereby reducing the internal resistance of the capacitor used as a power source.

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The present invention also includes a non-aqueous electrolytic capacitor having a cathode formed of the sheet of valve metal material. The anode of the electrolytic capacitor is formed of a valve metal sheet provided with an insulating, very thin, highly dielectric layer on the surface thereof. The cathode thereof is formed of a valve metal sheet including carbon particles on the surface thereof. Both the sheets of the anode and the cathode, disposed face-to-face, are wound or integrated, and they are accommodated in a container and immersed into electrolyte inside the container.

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The electrolyte of this electrolytic capacitor is prepared by adding, for example, an appropriate inorganic or organic salt to an ethylene glycol-based solvent. Even if a small amount of water is present in the electrolyte, only the metallic surface of the valve metal material is oxidized, whereby the carbon particles hold contact with the electrolyte to ensure conductivity. For this reason, the

electrolytic capacitor is far less likely to decrease in resistance, and the internal resistance thereof is far less likely to increase even after use for extended periods of time.

5

EMBODIMENTS

[Example 1]

A valve metal was formed of high-purity aluminum foil of four-nine grades, having a thickness of 20 μm . An electrode metal material was produced as described below. Acetylene black particles having an average particle diameter of 2 μm were dispersed uniformly on the surface of the metal foil in an amount of 50% by weight with respect to the metal foil per unit area of the foil, and subjected to a line pressure of 100 kg/cm^2 in a direction perpendicular to the surface of the foil by using reduction rollers. As a result, carbon-embedded metal foil, wherein numerous carbon particles were driven in the surface of the aluminum foil, was obtained.

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[Example 2]

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In the same way, an electrode metal material was produced as described below. Acetylene black particles having an average particle diameter of 2 μm were dispersed uniformly on the surface of high-purity aluminum foil of four-9 grade, having a thickness of 20 μm , at 50% by weight in the same way as described above, and subjected to a line pressure of 100 kg/cm^2 in a direction perpendicular to the surface of the foil by using rollers. Numerous carbon particles were thus driven in the surface of the aluminum

foil. After this, the carbon-embedded metal foil was subjected to electrolytic etching in a nitric acid-based etching solution to expose the carbon particles to the surface.

5

[Example 3]

In the same way, phenol-resin-based activated carbon particles having a particle diameter of $10 \mu\text{m}$ were dispersed uniformly on the surface of etched high-purity aluminum foil of four-9 grade, having a thickness of $20 \mu\text{m}$, which is used as a valve metal material, and then subjected to a pressure of 100 kg/cm^2 in a direction perpendicular to the surface of the foil by using reduction rollers. As a result, numerous carbon particles were driven in the surface of the aluminum foil. After this, the carbon-embedded metal foil was subjected to blasting to expose the carbon particles to the surface.

Electric double-layer capacitors were assembled by using these pieces of carbon-embedded metal foil for electrodes in accordance with Examples 1 to 3. To form a double-layer electrode, the carbon-embedded metal foil was coated with a paste including activated carbon particles. To prepare the paste, after obtaining a powder mixture of phenol-resin-based activated carbon particles having a particle diameter of $5 \mu\text{m}$, an ammonium salt of carboxymethyl cellulose $(\text{C}_6\text{H}_9\text{O}_5\text{CH}_2\text{CO}_2\text{NH}_4)_n$ and acetylene black in a weight ratio of 60.2: 2, methanol three times as much as the powder mixture and water five times as much as the powder mixture by weight were added to

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the powder mixture and kneaded. The electrode metal material foil was immersed in this paste for 15 seconds, whereby a film of the paste was formed on the metal foil 1. The foil was then dried for 1 hour at 100°C in the air to form an activated carbon layer (polarizable electrode). Next, the foil was cut and divided into two sheets, each having dimensions of 25 x 400 mm, thereby obtaining a pair of double-layer electrodes.

10 Next, aluminum leads 6 were connected to the double-layer electrodes, one lead to each electrode. The two double-layer electrodes were disposed face-to-face with a separator 5 therebetween, and then wound and formed into a coil. The coil was immersed into electrolyte wherein tetra ethyl ammonium perchlorate was added to propylene carbonate in a ratio of 0.5 mol/litter, and vacuuming was carried out, whereby the double-layer electrodes 3 and the separator 5 were impregnated with the electrolyte. The double-layer electrodes 3 and the separator 5 were then inserted into an 20 aluminum case 7, and the case 7 was sealed with a packing, whereby an electric double-layer capacitor was obtained.

[Example 4]

25 Just as in the case of Example 1, a valve metal material was formed by press-fitting carbon particles in the surface thereof. The valve metal material was electrolytically etched in a nitric-acid-based etching solution to expose the carbon particles to the surface thereof, and then subjected to oxidation at 400°C for 2 minutes in the air.

Just as in the case of Example 1, an activated carbon layer was formed on the surface of the valve metal material to obtain a double-layer electrode. By using the electrodes, an electric double-layer capacitor was obtained.

5

[Example 5]

Just as in the case of Example 3, a valve metal material was formed as described below. Phenol-resin-based activated carbon particles having a particle diameter of 10 μm were dispersed uniformly on aluminum foil having a thickness of 20 μm , and the foil was subjected to blasting to expose the carbon particles to the surface thereof.

To form double-layer electrodes, valve metal material foil was coated with a paste. To prepare the paste, after obtaining a powder mixture of phenol-resin-based activated carbon particles having a particle diameter of 5 μm , an ammonium salt of carboxymethyl cellulose and acetylene black in a weight ratio of 60.2: 2, methanol three times as much as the powder mixture and water five times as much as the powder mixture by weight were added to the powder mixture and kneaded. The electrode metal material foil was immersed in the paste for 15 seconds, whereby a film of the paste was formed on the metal foil 1. After this, the foil was dried for 1 hour at 180°C in the air to form an activated carbon layer (polarizable electrode). The foil was then cut to divide into two sheets, each having dimensions of 25 x 400 mm, thereby obtaining a pair of double-layer electrodes. Next, just as in the case of the above-mentioned examples, the

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double-layer electrodes were used to assemble an electric double-layer capacitor.

[Example 6]

5 Just as in the case of Example 3, a valve metal material of aluminum foil with a thickness of 20 μm , on which phenol-resin-based activated carbon particles having a particle diameter of 10 μm were dispersed uniformly, was subjected to blasting to expose the carbon particles on the surface.

10 Furthermore, this valve metal material was subjected to an oxidizing treatment at 400°C for 2 minutes in the air.

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15 The foil of the carbon-containing valve metal material obtained as described above was coated with a paste to form double-layer electrodes. The paste was prepared by kneading a powder mixture comprising phenol-resin-based activated carbon fiber having been cut to a length of 5 μm in the long-chain direction thereof, an ammonium salt of carboxymethylcellulose and acetylene black in a weight ratio 20 of 60.2: 2, respectively, together with methanol three times as much as the powder mixture and water five times as much as the powder mixture by weight added to the powder mixture. The electrode metal material foil was immersed in the paste for 15 seconds, whereby a film of the paste was applied on the 25 metal foil 1. The foil was then dried for 1 hour at 180°C in the air to form an activated carbon layer. The foil was then cut and divided into two sheets, each having dimensions of 25 x 400 mm, thereby obtaining a pair of double-layer electrodes. Next, just as in the case of the above-mentioned examples, an

electric double-layer capacitor was obtained.

[Example 7]

Just as in the case of Example 1, a valve metal material
5 was obtained by using aluminum film having a thickness of 20
μm, on which phenol-resin-based activated carbon particles
having a particle diameter of 10 μm were dispersed uniformly.

10 To prepare a mixture powder for a paste, a powder
mixture of phenol-resin-based activated carbon fiber having
been cut to a length of 5 μm in the long-chain direction
thereof, an ammonium salt of carboxymethylcellulose and
acetylene black in a weight ratio of 60.2: 2 was used. To
this powder mixture, methanol three times as much as the
powder mixture and water five times as much as the powder
mixture by weight were added in order to prepare a mixture
15 solution in slurry form. A collector 1 was then immersed in
the mixture solution for 15 seconds, whereby a polarizable
electrode 3 was formed as a film on the collector 1. Next,
20 the electrode was dried for 1 hour at 180°C in the air, and
the foil was cut and divided into two sheets, each having
dimensions of 25 x 400 mm, thereby obtaining a pair of
double-layer electrodes. Just as in the case of the above-
25 mentioned examples, an electric double-layer capacitor was
obtained.

[Comparative example]

Electrode metal material foil was formed of high-purity
aluminum foil of four-9 grade, having a thickness of 20 μm

and not including carbon particles. This valve metal material was immersed in a water solution of 1.0 N hydrochloric acid, 6.0 N nitric acid and 4.0 N phosphoric acid. The aluminum foil was subjected to etching by applying 5 direct current to the foil used as the anode. An electric double-layer capacitor was obtained just as in the case of Example 1.

The capacitors in accordance with these examples and the comparative example were charged at a constant voltage of 2.5 V for 1 hour. The capacitors were then discharged at a constant current of 100 mA, and the capacitance C and equivalent series resistance (ESR) values of the capacitors were measured. Furthermore, the capacitors were charged at a constant voltage of 2.8 V at 75°C in a constant temperature bath, and maintained in these conditions for 3000 hours. They were then discharged at a constant current of 100 mA, and the capacitance C and equivalent series resistance (ESR) values were measured in the same way. Table 1 shows the 10 15 20 results of the measurements.

Table 1

	Surface treatment	C (F)	ΔC (%)	ESR (m Ω)	ΔESR (%)
Example 1	Carbon-embedding	27	-16.1	55	16.5
Example 2	Carbon-embedding, etching	42	- 5.5	28	4.0
Example 3	Carbon-embedding, blasting	48	-	32	-
Example 4	Carbon-embedding, etching, oxidation	40	- 3.0	30	2.5
Example 5	Carbon-embedding, blasting, oxidation	48	- 6.2	32	4.5
Example 6	Carbon-embedding, blasting, oxidation	45	- 3.0	34	2.8
Example 7	Carbon-embedding	35	-18.5	60	14.8
Comparative	-	20	-27.5	80	22.0

The ΔC and ΔESR in Table 1 represent the change ratios of C and ESR from the initial C and ESR values to those obtained 3000 hours after treatments in the above-mentioned conditions, respectively.

As clearly disclosed in Table 1, it is understood that the capacitance values of the electric double-layer capacitors formed of the carbon-containing metal materials in accordance with the examples are larger than that of the comparative example, and that the ESR values of the former are smaller than that of the latter. This can be explained as follows: by using electrode foil to which carbon particles are added, the carbon particles are exposed to the surface of the electrode foil, whereby conductivity can be maintained at the interface between the electrode foil and the polarizable

electrode. Furthermore, according to this table, it is found that the stability of capacitance and ESR with respect to time can be enhanced by making the surface of the carbon-containing metal material rough by carrying out etching or 5 blasting, in particular, by carrying out oxidization to form a passive film.

A further embodiment of the invention is shown below with respect to use of carbon slurry in the method producing an electrode metal material.

10 [Example 8]

Aluminum of four-nine grade having 20 μm thick, was etched to produce a great number of pores opening to the surface, and was used to apply a carbon slurry of formulation of 1 part of carbon particles, 2 parts of ethanol and 20 parts of water. In this Example, acetylene black of mean particle size of 0.2 μm was used as carbon particles. The aluminum foil is soaked into the slurry for 10 seconds to 20 produce a slurry film on the surface, dried in air 30 minutes, and then rolled over the dried slurry by pressurizing at 100 kg/cm of line pressure, obtaining a carbon embedded metal sheet.

25 [Example 9]

In this Example, activated carbon powder from phenol resin having 2 μm of mean particle size was used to produce carbon embedded metal sheet, but other conditions were similar to Example 8.

[example 10]

Part of the carbon embedded metal sheet from Example 8 was electrolytically etched in a nitrate etching solution to expose carbon particles on the surface and then oxidized by 5 heating at 400°C for 2 minutes in air.

[Example 11]

Part of the carbon embedded metal sheet from Example 9 was blasted to expose carbon particles on the surface and then oxidized similarly to Example 10.

[Comparative 2]

A aluminum foil was used without applying carbon particles for an electrode metal material.

[Comparative 3]

A aluminum foil without applying carbon particles was oxidized by heating at 400°C in air and used for a electrode metal material.

The carbon embedded metal sheets from these Examples 8-20 11 and the comparative sheets were provided for fabricating electric double-layer capacitors. The carbon embedded metal sheets were applied with an activated carbon past which was formed of a powder of activated carbon from phenol resin ammonium carboxylmethylcellulose and acetylene black by 25 soaking and than dried, obtaining activated carbon laminate. the laminate was cut to two pieces of strips of 25 mm wide and 400 mm long as electric double layer electrodes. The two pieces of electrodes 3 and 5 were wound with a separator 5 to a coil, impregnated with an electrolyte containing tetraethyl

ammonium perchlorate and propylene carbonate and contained in a casing 7, obtaining electric double layer capacitors.

The electric double layer capacitors were tested by charging at constant 2.5V for 1 hour and discharging 100 mA of current to measure dielectric capacitance and ESR. thereafter, The same capacitors were charged at constant 2.8V at 75°C maintained 3000 hours, and discharged in constant 100 mA of current, and dielectric capacitance and ESR were measured. The results are shown in Table 2.

Table 2

	Surface treatment	C (F)	ΔC (%)	ESR (mΩ)	ΔESR (%)
Example 8	carbon slurry oxidation	42	-2.5	36	2.9
Example 9	carbon slurry oxidation	40	-3.0	38	3.5
Example 10	carbon slurry oxidation etching	48	-1.2	30	1.9
Example 11	carbon slurry oxidation blasting	45	-1.6	32	2.2
Comparative 2	no carbon-embedding,	25	-17.0	75	16.5
Comparative 3	No carbon-embedding, oxidation	12	-10.0	93	8.2

It is found from Table 2 that the capacitors using the carbon bedded metal material as supports for carbon electrodes are higher in capacitance and lower in ESR than Comparative examples using no carbon particles. Treatment of etching or blasting and particularly passivation of a metallic surface by oxidation are useful to increase Dielectric capacity and ESR stability.

A further embodiment of the invention is shown below

with respect to application to lithium ion non-aqueous batteries.

[Example 12]

5 Carbon-embedded metal foil having numerous carbon particles driven in the surface of the aluminum foil was obtained in the similar manner to Example 1, except that the acetylene black particles were dispersed in an amount of 30% by weight, aluminum foil having 50 μm . The carbon embedded alumina foil was electrolytically etched with a nitrate etchant to expose the carbon particles on the etched surface.

[Example 13]

10 part of the aluminum foil obtained in Example 12 was further anodized in an ammonium adipate solution applying 5v to produce supporters for positive electrode.

[Example 14]

15 Aluminum foil of four-nine grade having 10 μm was embedded with numerous carbon particles in a similar manner to Example 12, cladded onto both sides of a piece of stainless steel foil of 10 μm in thickness, and then, electrolytically etched with a nitrate solution expose the carbon particles from the etched surface.

20 [Example 15]

part of the carbon embedded aluminum foil obtained in Example 14 was anodized in the same way as Example 13 to produce supporters for positive electrode.

[Example 16]

Aluminum foil of four-nine grade having thickness of 10 μm was clad with both surfaces of a piece of stainless steel foil and carbon particles were dispersed uniformly on the aluminum foil in an amount of 25% by weight with respect to a unit area of the aluminum foil and pressed with a line pressure of about 100 kg/cm by using rollers for a cold rolling mil, then being embedded into the both surfaces of the aluminum foil. The carbon embedded clad foil obtained was etched by using a nitrate solution etchant as noted above Example 14 to expose the carbon particles from the etched surfaces of the aluminum foils, producing a supporter for positive electrode.

[Example 17]

Part of carbon embedded material of clad aluminum and stainless steel was anodized in ammonium adipate solution applying 5v as shown in Example 15 to produce supporters for positive electrode.

The supporters from these Examples 12-17 were supplied to fabricate lithium ion secondary batteries, wherein a slurry was prepared containing 90% by weight of LiCoO_2 as positive active substance, 7% by weight of acetylene black as conductive material, and 1% by weight of carboxyl-methylcellulose and 2% by weight of polyfluorovinylidene, and applied on both sides of the carbon embedded aluminum foil as a electrode metal material, and then, dried in air and pressed to make a positive electrode in thickness of 0.03

mm.

On the other hand, a negative electrode was produced of a slurry including 94% by weight of graphite, 2% by weight of carboxymethylcellulose and 4% by weight of styrene-butadiene rubber which slurry was applied on both sides of copper foil, and then dried and pressed to 0.22 mm thickness.

To fabricating batteries of AA battery size as shown in fig. 11, a sheet of the positive electrode 35 and a sheet of the negative electrode 37 prepared above were wound while stacking between which a separator 5 of polypropylene porous film was interposed, and placed in a can casing 71 with an electrolyte containing LiPF_6 in a mixture solvent. An inner bottom of the casing 71 was connected to the copper foil 63 to use for an outer negative terminal, and then an top opening of the casing was sealed with a metal cover 61 for using a positive terminal 61 which metal cover is connected to the electrode metal material 1 via leads, thus obtaining lithium ion secondary batteries having nominal capacity of 1800 mAh.

The batteries thus fabricated were tested to determine 2C and 0.2C capacitance after repeating 50 charges to 4.3V and discharges by 3.0V with a constant current of 100 mA in an incubator holding a temperature at 25°C. From these date, capacity retention of the tested batteries are evaluated and the results are shown in Table 4.

Table 3

	Capacity Retention (%)	
	0.2 C	2 C
Example 12	90	58
Example 13	95	63
Example 14	88	55
Example 15	94	61
Example 16	85	53
Example 17	92	60
Comparative 4	48	12

5 In Comparative Example 4 in Table 3, conventional aluminum foil of four-nine grade having thickness of 20 μm , which had not embedded with carbon particles, was used as electrode metal material to support a positive electrode for the same battery.

10 It is seen from Table 2 that the batteries of these Examples 12-17 are higher in capacity retention, particularly, exhibit more excellent high-rate performance as compared to the battery of Comparative Example 4. This shows that carbon particles embedded in and exposed to the surface of the electrode metal material can increase conductivity between a 15 positive electrode and a supporter using the electrode metal material for a positive electrode. Event though oxide film are gradually produced on the metallic surface of the electrode during the cycle test of repeating charges and discharges, conductivity due to carbon particles can be kept 20 high to maintain high capacity retention of the battery. Also, passivation formed on a carbon embedded electrode metal material by anodizing is found to maintain stability of the high retention performance even after the cycling test.

The electrode metal material in accordance with the present invention is used to form a capacitor electrode structure making contact with electrolyte, and includes numerous carbon particles on the surface of the valve metal material. Therefore, electric connection can be ensured between a carbon electrode member, such as activated carbon particles, to which the electrode metal material is joined, and the electrolyte, whereby a stable electrode structure can be obtained. For this reason, the electrode function of this electrode metal material is not deteriorated even if the material is used in the presence of water in the electrolyte.

In addition, the carbon particles of the electrode metal material can be fixed in the surface of the valve metal material so as to be exposed to the surface, thereby enhancing electric connection and joining to the electrode members.

Furthermore, when the surface of the valve metal material of the electrode metal material is coated with a passive film, high conductivity to the electrode members and the electrolyte can be ensured stably for extended periods of time. The electrode metal material in accordance with the present invention is coated with an activated carbon layer, and can be used as the double-layer electrodes of an electric double-layer capacitor. Therefore, it is possible to attain an electric double-layer capacitor having a low internal resistance and a large capacitance value.

Moreover, the electrode metal material, making contact

with electrolyte, is used as the cathode of an electrolytic capacitor, whereby it is possible to obtain a cathode having stable conductivity for extended periods of time. Therefore, it is possible to attain an electrolytic capacitor having a 5 low internal resistance and a large capacitance value.

INDUSTRIAL USABILITY

The electrode metal materials in accordance with the present invention can be produced in the fields of the metal industry and electronic component materials, and can be used as electrode materials for electric double-layer capacitors and electrolytic capacitors. Furthermore, the capacitors in accordance with the present invention can be widely produced and used as electronic components in the field of electronic component materials, and can be applied to a wide range of 10 various electronic apparatuses.

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CLAIMS

1. An electrode metal material for using in an electrode structure in contact with non-aqueous electrolyte, wherein the electrode metal material is a carbon-containing metal material comprising a valve metal material and numerous carbon particles fixed in a surface of the valve metal material and exposed to the surface thereof.

2. The electrode metal material according to claim 1, wherein said carbon particles are projected from the surface of said valve metal material to expose to said surface.

3. The electrode metal material according to claim 1, wherein the metallic surface of said carbon-containing metal material is coated with a passive film.

4. The electrode metal material according to claim 1, wherein said electrode metal material is coated with an activated carbon layer to form a double-layer electrode for an electric double-layer capacitor.

5. The electrode metal material according to claim 1, wherein said electrode metal material is a cathode of an electrolytic capacitor, making contact with non-aqueous electrolyte.

6. The electrode metal material according to Claim 1, wherein said electrode metal material is thin sheet.

7. The electrode metal material according Claim 1, wherein said carbon particles are formed of conductive carbon particles, such as graphite or carbon black.

8. The electrode metal material according to Claim 1, wherein said carbon particles are activated carbon particles.

9. The electrode metal material according to Claim 1, wherein said carbon particles have a mean diameter of the range of 0.01 to 50 μm .

10. The electrode metal material according to Claim 1, 5 wherein said carbon particles have one of particulate, granular and fibrous forms.

11. A method of producing an electrode metal material, being a carbon-containing metal material comprising a valve metal material and numerous carbon particles fixed in at least a surface of said valve metal material and exposed to said surface, wherein said method comprises the steps of:

15 including said carbon particles in a valve metal ingot by heating and pressurizing a mixture of valve metal powder and carbon powder in a container; and,

10 forming said obtained valve metal ingot into a desired shape so as to be used as said carbon-containing metal material.

20 12. A method of producing an electrode metal material, being a carbon-containing metal material comprising a valve metal material fixed numerous carbon particles in at least a 25 surface thereof, wherein said method comprises: dispersing carbon particles on the surface of a valve metal material; and embedding the carbon particles into the surface of said valve metal material by pressurizing said carbon particles onto the surface of said valve metal material to obtain said carbon-containing metal material.

25 13. The method of producing an electrode metal material according to claim 11, wherein said carbon embedding step uses a press method in which said carbon particles are driven

by using a die.

14. The method of producing an electrode metal material according to claim 11, wherein said carbon embedding step uses a rolling method in which said carbon particles are driven by using a roller.

15. The method of producing an electrode metal material according to claim 11, wherein said carbon embedding step is carried out when said valve metal material is formed by hot or cold working.

16. The method of producing an electrode metal material according to Claim 11, wherein the method comprises a step of coarsening the surface of said carbon-containing metal material.

17. The method of producing an electrode metal material according to Claim 11 or 12, wherein the method further comprises a further step of exposing said carbon particles to the surface of said carbon-containing metal material by etching said carbon-containing metal material in an acidic aqueous solution.

20 18. The method of producing an electrode metal material according to Claim 11 or 12, wherein the method comprises a step of exposing said carbon particles to the surface of said carbon-containing metal material by blasting said carbon-containing metal material.

25 19. The method of producing an electrode metal material according to claim 17, wherein the method comprises a step of forming a passive film on the metallic surface of said carbon-containing metal material after said step of exposing said carbon particles.

20. The method of producing an electrode metal material according to Claim 11 or 12, wherein said carbon particles are formed of conductive carbon particles, such as graphite or carbon black.

5 21. The method of producing an electrode metal material according to Claim 11 or 12, wherein said carbon particles are activated carbon particles.

10 22. The method of producing an electrode metal material according to Claim 11 or 12, wherein the diameter of said carbon particles is in the range of 0.01 to 50 μm .

15 23. The method of producing an electrode metal material according to Claim 11 or 12, wherein said carbon particles have one of particulate, granular and fibrous forms.

24. A capacitor comprising a pair of electrodes and non-aqueous electrolyte, wherein at least one electrode includes an electrode metal material which is a carbon-containing metal material comprising a valve metal material and numerous carbon particles fixed in the surface of said valve metal material and exposed to said surface.

20 25. The capacitor according to claim 24, wherein said capacitor is an electric double-layer capacitor, and said pair of electrodes is formed of electric double-layer electrodes each comprising said carbon-containing metal material and an activated carbon layer formed in contact with said carbon particles on the surface of said metal material.

25 26. The capacitor according to claim 25, wherein said valve metal material is a flexible sheet, said pair of electric double-layer electrodes is disposed face-to-face with a separator therebetween and wound, and enclosed in a

container to obtain a winding type electric double-layer capacitor.

27. The capacitor according to claim 25, wherein said activated carbon layers of said pair of electric double-layer electrodes are accommodated in a container with a separator therebetween, and said valve metal materials of said electrodes are accommodated in the metallic lid and bottom portions of a container, which are coupled so as to be insulated from each other.

28. The capacitor according to claim 27, wherein said metallic lid and bottom portions of said container are clad with said valve metal materials.

29. The capacitor according to claim 24, wherein said capacitor is an electrolytic capacitor, one of said electrode metal materials is used as the cathode, and the other electrode metal material having a dielectric insulating film is used as the anode.

30. The capacitor according to Claim 24, wherein said carbon particles are formed of conductive carbon particles, such as graphite or carbon black.

31. The capacitor according to Claim 24, wherein said carbon particles are activated carbon particles.

32. The capacitor according to Claim 24, wherein the diameter of said carbon particles is in the range of 0.01 to 50 μm .

33. The capacitor according to Claim 24, wherein said carbon particles have one of particulate, granular and fibrous forms.

34. The capacitor according to Claim 24, wherein a

passive film is formed on the metallic surface of said valve metal material.

35. A method of producing an electric double-layer capacitor comprising a pair of electric double-layer electrodes each formed of an activated carbon layer formed on the surface of a valve metal material, a separator for separating said pair of electric double-layer electrodes and non-aqueous electrolyte, wherein said method comprises the steps of:

10 forming a carbon-containing metal material in which numerous carbon particles are fixed in at least a the surface of a valve metal material and exposed to said surface;

15 applying a paste containing activated carbon particles to the surface of said carbon-containing metal material; and

20 drying and curing said paste to obtain said electric double-layer electrodes.

36. The method of producing a capacitor according to claim 35, wherein, after the step of forming said carbon-containing metal material, said method further comprises a step of exposing said carbon particles on the surface of said metal material by electrolytic etching said metal material in an acidic aqueous solution.

25 37. A method of producing a button-type electric double-layer capacitor in which a pair of electric double-layer electrodes, each having an activated carbon layer formed on the surface of an electrode metal material, is accommodated in a container with the activated carbon layers laminated via a separator therebetween, and the electrode metal materials are coupled to the metallic lid and bottom

portions of the container, both portions being insulated from each other, wherein said method comprises the steps of;

5 forming a carbon-containing metal material, as the electrode metal material, in which numerous carbon particles are included at least in the surface of a valve metal material and exposed to said surface; and

applying the activated carbon layers to the surfaces of the valve metal materials to obtain the electric double-layer electrodes.

10 38. The method of producing an electric double-layer capacitor according to claim 37, including a step of previously carrying out cladding of the metallic bottom portion of said container with said valve metal materials at so as to accomplish integration.

15 39. A method of producing an electrolytic capacitor in which an anode formed of a valve metal material having a dielectric insulating film on the surface thereof and a cathode formed of a valve metal material are disposed face-to-face in non-aqueous electrolyte, wherein said method 20 comprises a steps of forming a carbon-containing metal material in which numerous carbon particles are fixed in at least a surface of the valve metal material and exposed to said surface so that the carbon-containing metal material is used as the electrode metal material for the cathode.

25 40. The method of producing a capacitor according to claim 35, 37 or 39, wherein the step of forming the carbon-containing metal material includes a carbon embedding step of driving the carbon particles into the surface of the valve metal material by pressurizing the carbon particles dispersed

on the surface of said valve metal material to obtain the carbon-containing metal material.

41. The method of producing a capacitor according to claim 40, wherein said carbon embedding step uses a press 5 method in which said carbon particles are driven by using a die.

42. The method of producing a capacitor according to claim 40, wherein said carbon embedding step uses a rolling method in which the carbon particles are driven by using rollers.

43. The method of producing a capacitor according to claim 41, wherein said carbon embedding step is carried out in a hot or cold working step to form the valve metal material.

44. The method of producing an electrode metal material according to claim 40, including a step of coarsening the 15 surface of said carbon-containing metal material.

45. The method of producing an electrode metal material according to claim 40, wherein the method further includes a 20 step of exposing said carbon particles to the surface of the carbon-containing metal material by electrolytically etching the surface of the carbon-containing metal material in an acidic aqueous solution.

46. The method of producing an electrode metal material according to Claim 40, wherein the method further includes a 25 step of exposing said carbon particles to the surface of the carbon-containing metal material by blasting the carbon-containing metal material.

47. The method of producing an electrode metal material

according to claim 45, wherein the method further includes a step of forming a passive film on the metallic surface of the carbon-containing metal material after said carbon particle exposing step.

5 48. The method of producing an electrode metal material according to Claim 41, wherein said carbon particles are formed of conductive carbon particles, such as graphite or carbon black.

10 49. The method of producing a capacitor according to claim 42, wherein said carbon embedding step is carried out in a hot or cold working step to form the valve metal material.

15 50. The method of producing an electrode metal material according to Claim 42, wherein the method further includes a step of exposing said carbon particles to the surface of the carbon-containing metal material by blasting the carbon-containing metal material.

20 51. The method of producing an electrode metal material according to Claim 43, wherein the method further includes a step of exposing said carbon particles to the surface of the carbon-containing metal material by blasting the carbon-containing metal material.

25 52. The method of producing an electrode metal material according to Claim 42, wherein said carbon particles are formed of conductive carbon particles, such as graphite or carbon black.

53. The method of producing an electrode metal material according to Claim 43, wherein said carbon particles are formed of conductive carbon particles, such as graphite or

carbon black.

5

54. A non-aqueous secondary battery comprising a positive electrode and a negative electrode and non-aqueous electrolyte to make contact to both the electrodes therein, wherein the positive electrode is formed on an electrode metal material which is a carbon-containing metal material comprising a valve metal material and numerous carbon particles fixed in and exposed to a surface of the valve metal material.

10

55. The non-aqueous secondary battery according to Claim 54, wherein the electrode metal material is a clad material comprising the carbon-containing metal material and a base metal plate.

15

56. The non-aqueous secondary battery according to Claim 54, wherein a passive film thicker than a film to be naturally oxidized is formed on the metallic surface of the valve metal material.

20

57. The non-aqueous secondary battery according to Claim 56, wherein the passive film has higher withstand voltage than 3V.

58. The non-aqueous secondary battery according to Claim 54, wherein the base metal is nickel or stainless steel.

25

59. A method for producing a non-aqueous secondary battery comprising: a positive electrode; a negative electrode; and non-aqueous electrolyte to make contact with both the electrodes therein, wherein the method comprises: forming a carbon containing electrode metal material by embedding carbon particles into the surface of a sheet of valve metal material, the carbon particles exposing on the

surface of the sheet; and applying a paste containing positive active substance on the carbon containing electrode metal material for producing the positive electrode.

5 60. The method according to Claim 59, wherein the method further includes cladding the carbon containing electrode metal material on a base metal plate in order to embed the carbon particles on the surface of the sheet.

10 61. The method according to Claim 59, wherein the method further includes previously cladding a sheet of the valve metal material on a base metal plate to produce a clad which is embedded with the carbon particles.

15 62. The method according to Claim 60, wherein the method further includes form a passive film on the surface of the carbon containing electrode metal material.

63. The method according to Claim 63, wherein the passive film is formed by anodizing the carbon containing electrode metal material.

20 64. The method of an electrode metal material according to Claim 13, wherein in the step of dispersing carbon particles, a slurry containing the carbon particles is applied to the surface.

65. The method according to Claim 64, wherein the slurry containing the carbon particles and solvent, without containing a binder.

25 66. The method according to Claim 64, wherein the method includes drying the slurry after applying on the valve metal material.

67. The method according to Claim 64, wherein the valve metal material is roughened on the surface.

68. The method according to Claim 67, wherein the roughening of the valve metal material is performed by electrolytically etching.

5 69. The method according to Claim 67, wherein the roughening of the valve metal material is performed by chemically etching.

70. The method according to Claim 67, wherein the roughening of the valve metal material is performed by blasting technique .

10 71. The method according to claim 64, wherein said carbon embedding step uses a press method in which said carbon particles are driven by using a die.

15 72. The method of producing an electrode metal material according to claim 64, wherein said carbon embedding step uses a rolling method in which said carbon particles are driven by using a roller.

73. The method of producing an electrode metal material according to claim 72, wherein the roller is an roller embossed on its surface.

20 74. The method of producing an electrode metal material according to Claim 64, wherein the method comprises a step of coarsening the surface of said carbon-containing metal material.

25 75. The method of producing an electrode metal material according to Claim 64, wherein the method further comprises a further step of exposing said carbon particles to the surface of said carbon-containing metal material by etching said carbon-containing metal material in an acidic aqueous solution.

76. The method of producing an electrode metal material according to Claim 64, wherein the method comprises a step of exposing said carbon particles to the surface of said carbon-containing metal material by blasting said carbon-containing metal material.

5

77. The method of producing an electrode metal material according to claim 75, wherein the method comprises a step of forming a passive film on the metallic surface of said carbon-containing metal material after said step of exposing said carbon particles.

10

78. The method of producing an electrode metal material according to Claim 77, the step of forming a passive film includes heat treating of the carbon-containing electrode material in air.

15

79. The method of producing an electrode metal material according to Claim 78, the heat treating is performed at 300 - 620°C.

20

80. The method of producing an electric double-layer capacitor according to Claim 35, wherein in the step of forming the carbon-containing metal material, a slurry containing the carbon particles is applied to the surface of the valve metal material, dried and drive into the surface of the valve metal material by pressing.

25

81. The method according to Claim 80, wherein the slurry containing the carbon particles and solvent, without containing a binder.

82. The method according to Claim 80, wherein the method includes drying the slurry after applying on the valve metal material.

83. The method according to Claim 80, wherein the valve metal material is roughened on the surface.

84. The method according to Claim 83, wherein the roughening of the valve metal material is performed by
5 electrolytically etching.

85. The method according to Claim 83, wherein the roughening of the valve metal material is performed by chemically etching.

86. The method according to Claim 83, wherein the roughening of the valve metal material is performed by
10 blasting.

87. The method according to claim 80, wherein said carbon embedding step uses a press method in which said carbon particles are driven by using a die.

88. The method of producing an electric double-layer capacitor according to claim 80, wherein said carbon embedding step uses a rolling method in which said carbon particles are driven by using a roller.

89. The method of producing an electric double-layer
20 capacitor according to claim 88, wherein the roller is an roller embossed on its surface.

90. The method of producing an electric double-layer capacitor according to Claim 80, wherein the method comprises a step of coarsening the surface of said carbon-containing
25 metal material.

91. The method of producing an electric double-layer capacitor according to Claim 80, wherein the method further comprises a further step of exposing said carbon particles to the surface of said carbon-containing metal material by

etching said carbon-containing metal material in an acidic aqueous solution.

92. The method of producing an electric double-layer capacitor according to Claim 80, wherein the method comprises 5 a step of exposing said carbon particles to the surface of said carbon-containing metal material by blasting said carbon-containing metal material.

93. The method of producing a capacitor according to claim 80, wherein, after the step of forming said carbon-containing metal material, said method further comprises a step of exposing said carbon particles on the surface of said metal material by electrolytic etching said metal material in an acidic aqueous solution.

94. A method of producing a button-type electric double-layer capacitor according to Claim 80, wherein in the step of forming the carbon-containing metal material, a slurry containing the carbon particles is applied to the surface of the valve metal material, dried and embedded into the surface of the valve metal material by pressing.

95. The method of producing an electric double-layer capacitor according to claim 94, wherein the method further including a step of previously cladding of the metallic bottom portion of said container with said valve metal materials at so as to accomplish integration.

96. The method according to Claim 94, wherein the slurry containing the carbon particles and solvent, without containing a binder.

97. The method according to Claim 94, wherein the method includes drying the slurry after applying on the valve

metal material.

98. The method according to Claim 94, wherein the valve metal material is roughened on the surface.

5 99. The method according to Claim 98, wherein the roughening of the valve metal material is performed by electrolytically etching.

100. The method according to Claim 98, wherein the roughening of the valve metal material is performed by chemically etching.

10 101. The method according to Claim 98, wherein the roughening of the valve metal material is performed by blasting sand technique .

15 102. The method according to claim 94, wherein said carbon embedding step uses a press method in which said carbon particles are driven by using a die.

103. The method of producing a button-type electric double-layer capacitor according to claim 94, wherein said carbon embedding step uses a rolling method in which said carbon particles are driven by using a roller.

20 104. The method according to claim 72, wherein the roller is an roller embossed on its surface.

105. The method of producing a button-type electric double-layer capacitor according to Claim 94, wherein the method comprises a step of coarsening the surface of said 25 carbon-containing metal material.

106. The method of producing a button-type electric double-layer capacitor according to Claim 94, wherein the method further comprises a further step of exposing said carbon particles to the surface of said carbon-containing

metal material by etching said carbon-containing metal material in an acidic aqueous solution.

107. The method of producing a button-type electric double-layer capacitor according to Claim 94, wherein the 5 method comprises a step of exposing said carbon particles to the surface of said carbon-containing metal material by blasting said carbon-containing metal material.

108. A method of producing an electrolytic capacitor according to claim 39, wherein in the step of forming a carbon-containing metal material, a slurry containing the carbon particles is applied to the surface of the valve metal material, dried and drive into the surface of the valve metal material by pressing.

109. The method according to Claim 108, wherein the method includes drying the slurry after applying on the valve metal material.

110. The method according to Claim 108, wherein the valve metal material is roughened on the surface.

111. The method according to Claim 110, wherein the 20 roughening of the valve metal material is performed by electrolytically etching.

112. The method according to Claim 110, wherein the roughening of the valve metal material is performed by chemically etching.

25 113. The method according to Claim 110, wherein the roughening of the valve metal material is performed by blasting sand technique .

114. The method according to claim 108, wherein said carbon embedding step uses a press method in which said

carbon particles are driven by using a die.

115. The method of producing an electrolytic capacitor according to claim 108, wherein said carbon embedding step uses a rolling method in which said carbon particles are
5 driven by using a roller.

116. The method of producing an electrolytic capacitor according to claim 112, wherein the roller is an roller embossed on its surface.

117. The method of producing an electrolytic capacitor according to Claim 108, wherein the method comprises a step of coarsening the surface of said carbon-containing metal material.

118. The method of producing an electrolytic capacitor according to Claim 108, wherein the method further comprises a further step of exposing said carbon particles to the surface of said carbon-containing metal material by etching said carbon-containing metal material in an acidic aqueous solution.

119. The method of producing an electrolytic capacitor according to Claim 108, wherein the method comprises a step of exposing said carbon particles to the surface of said carbon-containing metal material by blasting said carbon-containing metal material.

120. The method of producing an electrolytic capacitor according to claim 118, wherein the method comprises a step of forming a passive film on the metallic surface of said carbon-containing metal material after said step of exposing said carbon particles.

ABSTRACT

The present invention relates to an electrode metal material for batteries, capacitors, etc, used in contact with non-aqueous electrolyte, and particularly to a capacitor formed of the electrode metal material, and provides a valve metal material capable of decreasing the internal resistance of the capacitor. The electrode metal material comprises a valve metal material and numerous carbon particles included in the surface of the valve metal material. The carbon particles are further fixed in the surface of the valve metal material so as to expose to the surface. The electrode metal material is coated with an activated carbon layer and used as a double-layer electrode for an electric double-layer capacitor. The carbon particles included in the surface ensure conduction between the activated carbon layer and the valve metal material. With this configuration, even if the surface of the valve metal material is oxidized, the internal resistance of the electrode is not decreased, the internal resistance of the capacitor is decreased, and the capacitance of the capacitor is increased.

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15
20

Fig. 1

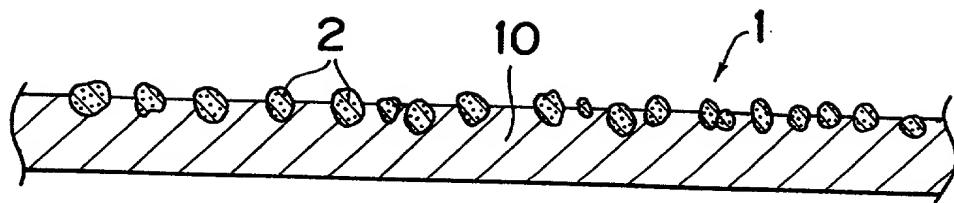


Fig. 2

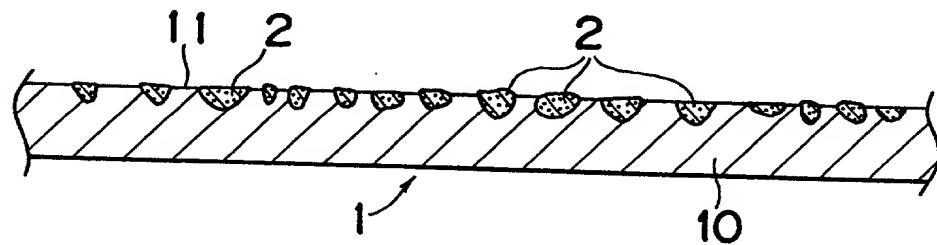


Fig. 3

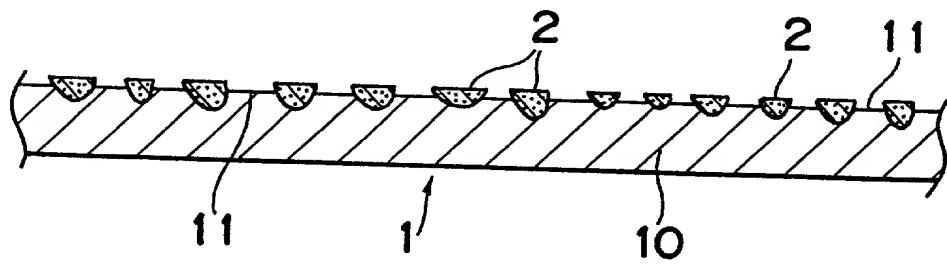


Fig. 4

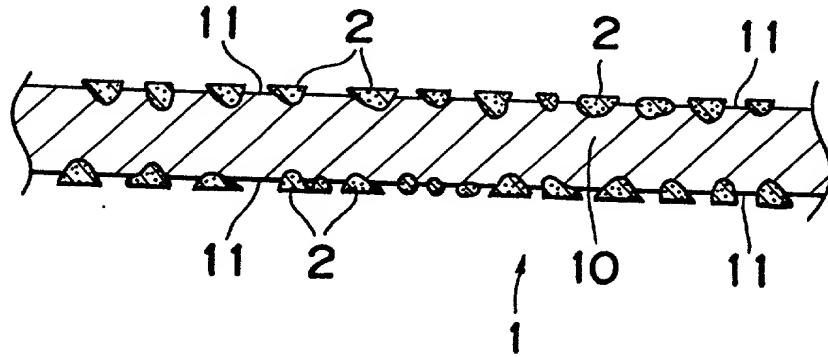


Fig. 5

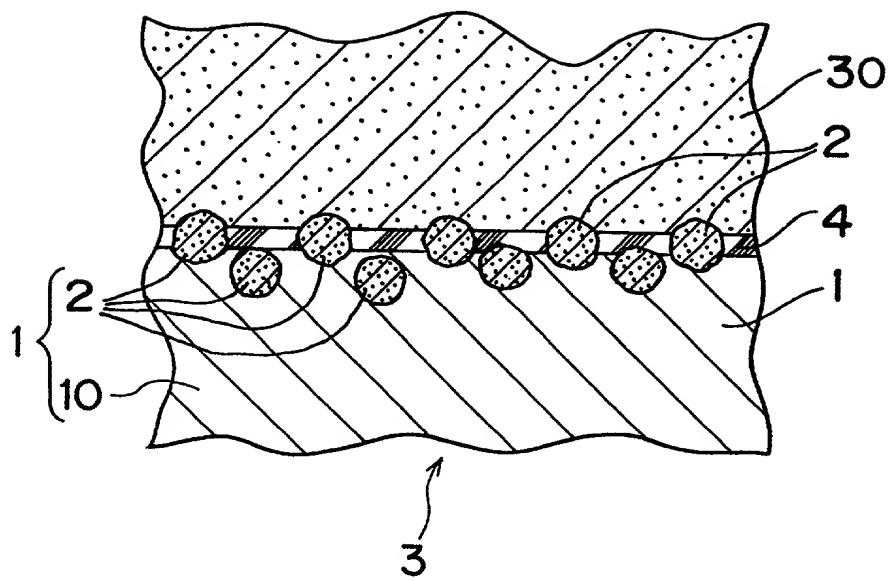


Fig. 6

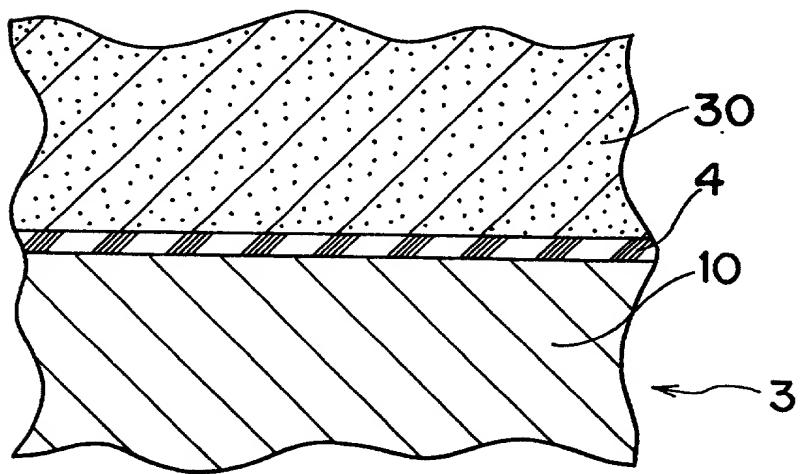


Fig. 7

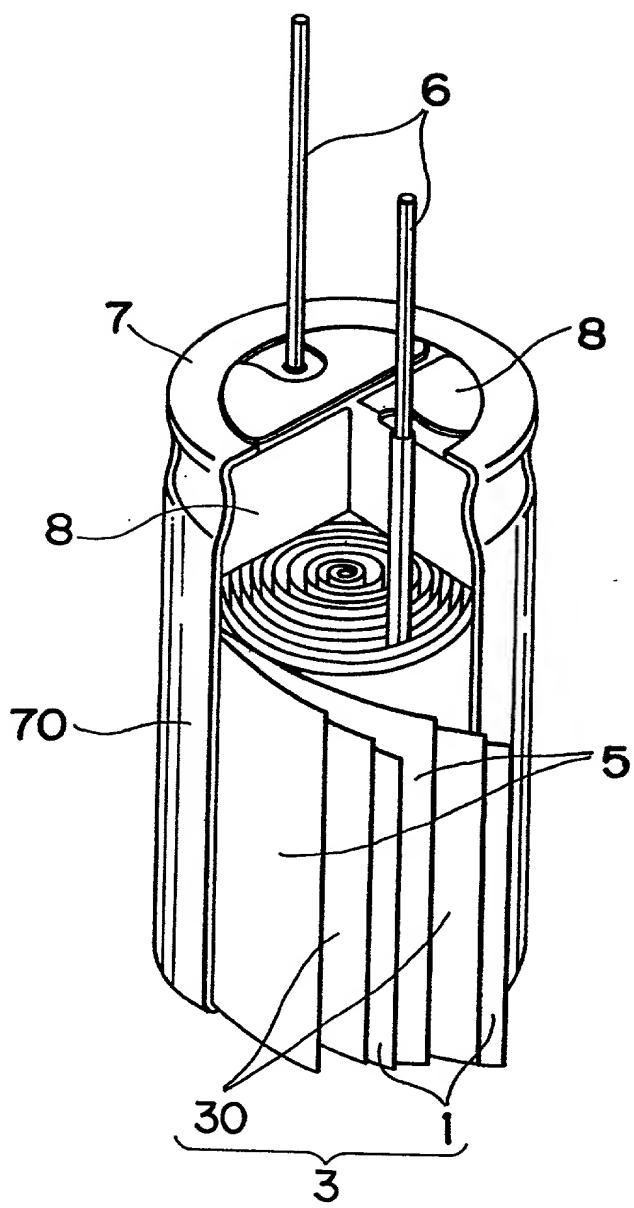


Fig. 8

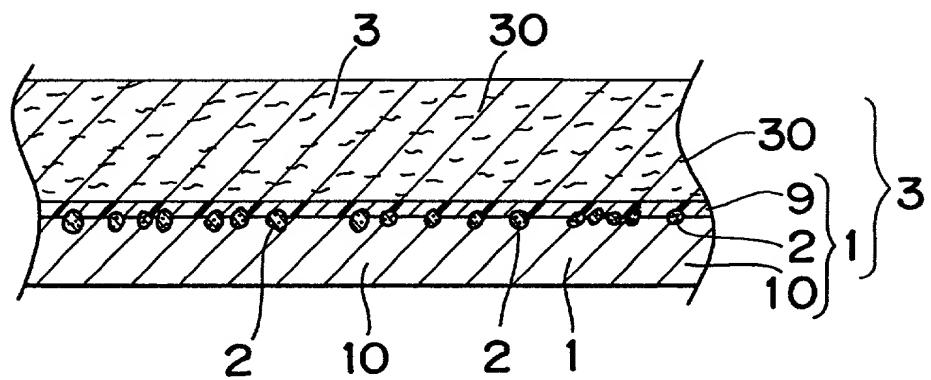


Fig. 9

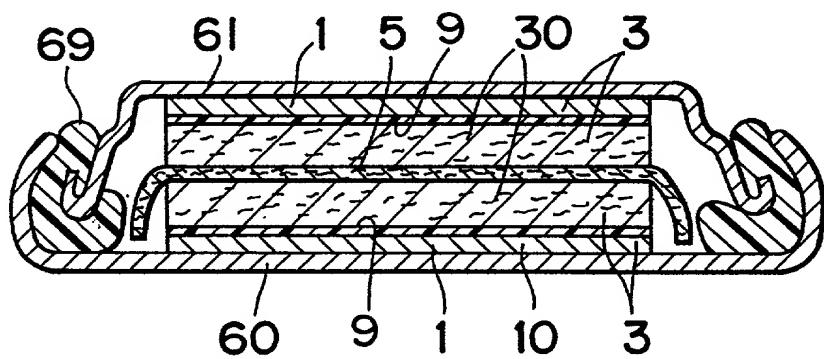


Fig 10

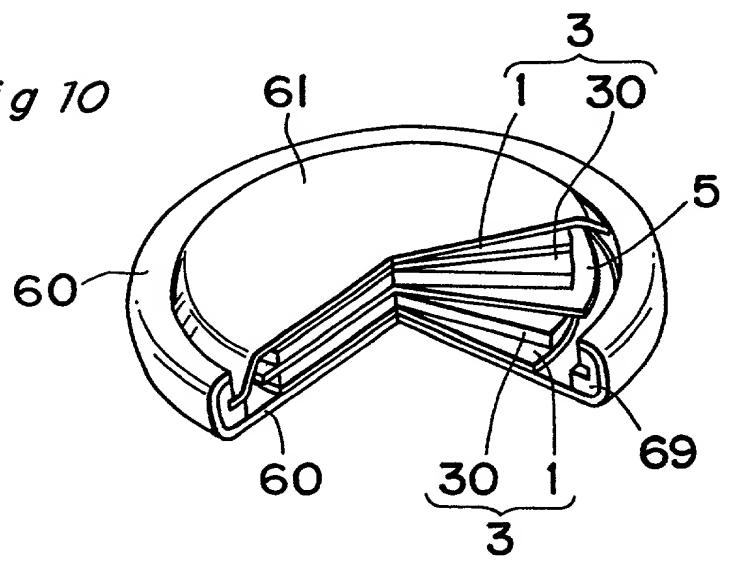


Fig. 11

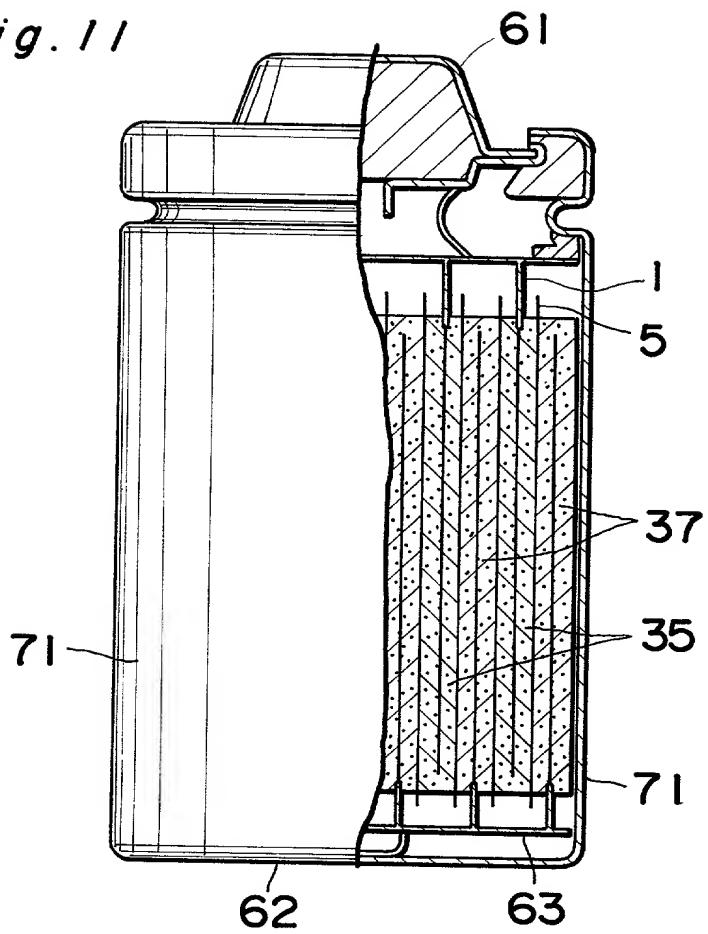
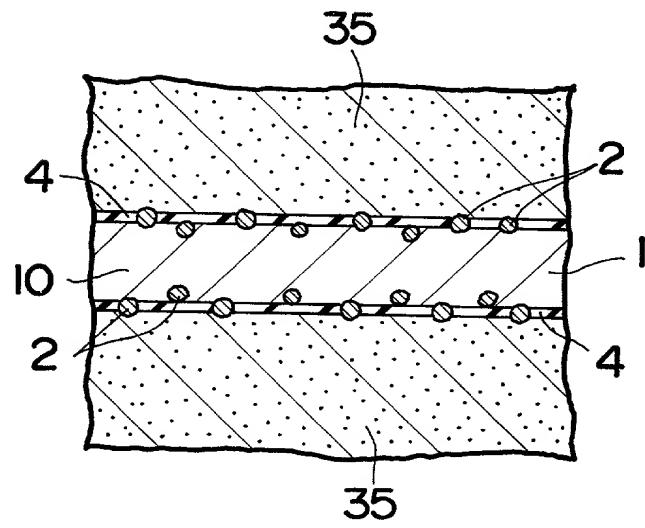


Fig. 12



DECLARATION AND POWER OF ATTORNEY FOR U.S. PATENT APPLICATION

(X) Original () Supplemental () Substitute () PCT () Design

As a below named inventor, I hereby declare that: my residence, post office address and citizenship are as stated below next to my name; that I verily believe that I am the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural inventors are named below) of the subject matter which is claimed and for which a patent is sought on the invention entitled:

Title: ELECTRODE METAL MATERIAL, CAPACITOR AND BATTERY FORMED OF THE MATERIAL AND METHOD OF PRODUCING THE MATERIAL AND THE CAPACITOR AND BATTERY

of which is described and claimed in:

(X) the attached specification, or
 () the specification in the application Serial No. _____ filed _____;
 and with amendments through _____ (if applicable), or
 () the specification in International Application No. PCT/ _____, filed _____, and as amended
 on _____ (if applicable).

I hereby state that I have reviewed and understand the content of the above-identified specification, including the claims, as amended by any amendment(s) referred to above.

I acknowledge my duty to disclose to the Patent and Trademark Office all information known to me to be material to patentability as defined in Title 37, Code of Federal Regulations, §1.56.

I hereby claim priority benefits under Title 35, United States Code, §119 (and §172 if this application is for a Design) of any application(s) for patent or inventor's certificate listed below and have also identified below any application for patent or inventor's certificate having a filing date before that of the application on which priority is claimed:

COUNTRY	APPLICATION NO.	DATE OF FILING	PRIORITY CLAIMED
Japan	P 10-011077	January 23, 1998	Yes
Japan	P 10-011078	January 23, 1998	Yes
Japan	P 11-286520	October 7, 1999	Yes
Japan	P 2000-113776	April 14, 2000	Yes

I hereby claim the benefit under Title 35, United States Code, §120 of any United States application(s) listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in the prior United States application in the manner provided by the first paragraph of Title 35, United States Code, §112, I acknowledge the duty to disclose information material to patentability as defined in Title 37, Code of Federal Regulations, §1.56 which occurred between the filing date of the prior application and the national or PCT international filing date of this application.

APPLICATION SERIAL NO.	U.S. FILING DATE	STATUS: PATENTED, PENDING, ABANDONED
09/381,680	September 23, 1999	Abandoned

And I hereby appoint John T. Miller, Reg. No. 21,120; Michael R. Davis, Reg. No. 25,134; Matthew M. Jacob, Reg. No. 25,154; Jeffrey Nolton, Reg. No. 25,408; Warren M. Cheek, Jr., Reg. No. 33,367; Nils E. Pedersen, Reg. No. 33,145 and Charles R. Watts, Reg. No. 33,142, who together constitute the firm of WENDEROTH, LIND & PONACK, L.L.P., attorneys to prosecute this application and to transact all business in the U.S. Patent and Trademark Office connected therewith.

I hereby authorize the U.S. attorneys named herein to accept and follow instructions from AOYAMA & PARTNERS as to any action to be taken in the U.S. Patent and Trademark Office regarding this application without direct communication between the U.S. attorneys and myself. In the event of a change in the persons from whom instructions may be taken, the U.S. attorneys named herein will be so notified by me.

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Residence & Citizenship	CITY	STATE OR COUNTRY	COUNTRY OF CITIZENSHIP	
Post Office Address	ADDRESS	CITY	STATE OR COUNTRY	ZIP CODE

I further declare that all statements made herein of my own knowledge are true, and that all statements on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code, and that such willful false statements may jeopardize the validity of the application or any patent issuing thereon.

1st Inventor Seiji Noraka Date October 3, 2000
 2nd Inventor Masakazu Tanahashi Date October 3, 2000
 3rd Inventor Mikinari Shimada Date October 3, 2000
 4th Inventor Jamao Kojima Date October 3, 2000
 5th Inventor Munehiro Tabata Date October 3, 2000
 6th Inventor _____ Date _____
 7th Inventor _____ Date _____

The above application may be more particularly identified as follows:

U.S. Application Serial No. _____ Filing Date _____

Applicant Reference Number 532318 Atty Docket No. _____

Title of Invention ELECTRODE METAL MATERIAL, CAPACITOR AND BATTERY FORMED OF THE MATERIAL AND METHOD OF PRODUCING THE MATERIAL AND THE CAPACITOR AND BATTERY